

21

Date: Wednesday, 5/16/2007 8:13:12 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 32372	
Estimate Number : 12530	
P.O. Number : N/A	Part Number : D35471
This Issue : 5/16/2007 S.O. No. : N/A	Drawing Number : D3547
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 31124	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 5/22/2007 Qty: 10 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:A New Issue 06-09-18 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S125	2024-T3 .125 sheet
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Comment: Qty.: 0.0557 sf(s)/Unit Total : 0.5565 sf(s)  
 2024-T3 .125 Sheet  
 (M2024T3S0125)  
 Batch: 4102087

SAD 07/06/01

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3547  
 Dwg Rev: A  
 Prog Rev: A  
 \*\*\*\*Ensure Grain Direction is Correct\*\*\*\*\*

SAD 07/06/01

(16)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/01 (16)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 07.06.04 (10)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Bend as per Dwg D3557

SAD 07/07/12

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/07/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:13:12 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32372

Part Number: D35471

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counted  
in 07-07-12 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

in 07-07-12

(X10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

in 101575

BRM/07-07-17

(10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 07/07/17 (10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/17/18 (10)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.18  
HJ

Job Completion



07-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	32372
<b>Description: Bracket</b>		<b>Part Number:</b>	D3547-1
<b>Inspection Dwg: D3547 Rev: A</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.313	+/-0.010	0.313	✓		Vern	
0.913	+/-0.010	0.910	✓		Vern	
2.054	+/-0.010	2.059	✓		Height gage	
2.38	+/-0.030	2.38	✓		Vern	
0.438	+/-0.010	0.437	✓		Vern	
2.813	+/-0.010	2.815	✓		Vern	
0.575	+/-0.010	0.579	✓		Vern	
1.100	+/-0.010	1.108	✓		Height gage	
1.625	+/-0.010	1.620	✓		Vern	
2.150	+/-0.010	2.155	✓		Height vern	
2.675	+/-0.010	2.680	✓		Vern	
3.25	+/-0.030	3.26	✓		Vern	
Ø0.172	+0.005/-0.001	Ø0.174	✓		Vern	
Ø0.323	+0.006/-0.001	Ø0.324	✓		Vern	
0.125	+/-0.010	0.124	✓		Vern	

<b>Measured by:</b>	SAD	<b>Audited by:</b>	SD	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/06/01	<b>Date:</b>	02.06.04	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	07.03.21	New Issue	KJ/JLM	BE

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3547</b>	REV. A SHEET 1 OF 1
DATE <b>06.10.06</b>		TITLE <b>BRACKET</b>	SCALE 1:1
REV	DATE	DESCRIPTION	
A	06.10.06	NEW ISSUE	